

Date: Monday, 11/6/2006 2:40:36 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING  
 Job Number : 29353B  
 Estimate Number : 10395  
 P.O. Number : N/A Part Number : D29685  
 This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2968  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1  
 Previous Run : 28865B Material : N/A  
 Due Date : 11/30/2006 Qty: 30 Um: Each  
 Written By :                       
 Checked & Approved By :                       
 Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NT3000W500 4130 Tube 3"ODx.5"W



Comment: Qty.: 0.0587 f(s)/Unit Total : 1.7609 f(s) 36"  
 Material: AISI 4130 Ø 3.00 .500" WALL " Bar  
 (M4130N-R0.750) Batch: M102020  
 Identify AS D2968-1

                     06/11/13

50

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE  
 1-Turn Blank as per Folio FA049 and Dwg D2968  
 2-Deburr, no sharp edges

                     06/11/13

50

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

                     06/11/13

50

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

                     06/11/13

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:                     

                     51396

                     06/11/15 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 20/11/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 29353B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



53

Comment: FINAL INSPECTION/W/O RELEASE

206/11/16

Job Completion



U 206/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

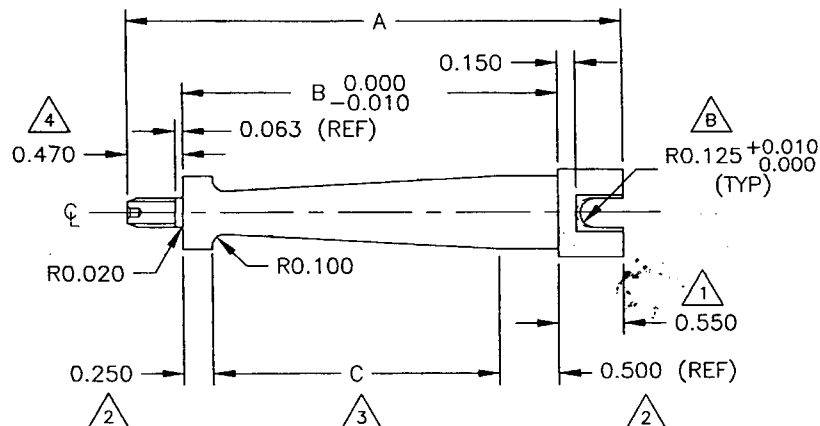
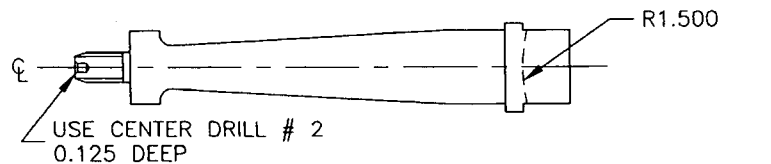
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

**D2968-1 AND D2968-3 STEM:**

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

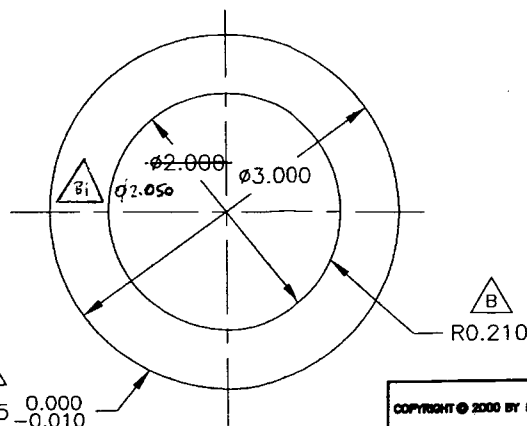
△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2968-5 RING:**

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

RELEASED

UNDER REVIEW

USE 2968-1 STEM FOR -041  
USE 2968-3 STEM FOR -043

**D2968-041 AND D2968-043 TOW RING:**

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING

HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART
CHECKED	RF	DART AEROSPACE LTD.
DATE	00.05.31	DRAWING NO. D2968
		TITLE TOW RING

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WORK ORDER  
29353B  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT

1010106 2.05D LAS 2.000

REV. B  
SHEET 1 OF 1  
SCALE 1:1